

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016447**Date Inspected:** 23-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 9DW

ABF Request No: 08212010-2

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between deck panel and edge panel of OBG segment 9DW at intersection of OBG segment 9CW on counter weight side. Inspection was carried out on repair areas only. The weld designations were as follows:

CA065-002 (OBG 9DW, EP to DP, C.W side @ 9CW)

OBG SEGMENT 9DW-9CW

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This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the bottom panel splice weld between OBG segment 9CW and 9DW. Inspection was carried out on repair areas only. The weld designations were as follows:

OBW9C-003 (OBG 9DW-9CW, BP)

### OBG SEGMENT 9EW

ABF Report No: UT-9W-093R1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between side panel and edge panel of OBG segment 9EW at intersection of OBG segment 9DW on cross beam side. The weld designations were as follows:

CA068-001 (OBG 9EW, EP to SP, C.B side @ 9DW)

### OBG SEGMENT 10AW

ABF Report No: UT-10W-020R1

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between deck panel and edge panel of OBG segment 10AW at intersection of OBG segment 9EW on cross beam side. The weld designations were as follows:

CA059\*-040 (OBG 10AW, EP to DP, C.B side @ 9EW)

### OBG SEGMENT 9EW

ABF Report No: UT-9W-095R1

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between deck panel and edge panel of OBG segment 9EW at intersection of OBG segment 10AW on cross beam side. The weld designations were as follows:

CA068-006 (OBG 9EW, EP to DP, C.B side @ 10AW)

### OBG SEGMENT 9EW

ABF Report No: UT-9W-096R1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between side panel and edge panel of OBG segment 9EW at

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intersection of OBG segment 10AW on cross beam side. The weld designations were as follows:

CA068-005 (OBG 9EW, EP to SP, C.B side @ 10AW)

### MAGNETIC PARTICLE TESTING

#### OBG SEGMENT 9DW

ABF Request No: 08212010-2

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing on the hold back welds between deck panel and edge panel of OBG segment 9DW at intersection of OBG segment 9CW on counter weight side.

The Inspection was carried out on repair areas only. The weld identification numbers were.

CA065-002 (OBG 9DW, EP to DP, C.W side @ 9CW)

No relevant indications were observed by this QA Inspector on this date.

#### OBG SEGMENT 9DW-9CW

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the bottom panel splice weld between OBG segment 9CW and 9DW. The Inspection was carried out on repair areas only. The weld identification numbers were.

OBW9C-003 (OBG 9DW-9CW, BP)

No relevant indications were observed by this QA Inspector on this date.

### ULTRASONIC TESTING

#### OBG SEGMENT 9DW-9EW

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the side panel splice weld between OBG segment 9DW and 9EW on the counter weight side. The weld designations were as follows:

OBW9C-007 (OBG 9DW-9EW, SP, CW side)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

#### Summary of Conversations:

No significant conversations were reported on this date.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer